



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBWST13045
Job Sheet 196556



Part No: RBWST13045

Job Qty: 2 pcs

Part Name: Nitrogen Tire Inflator



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/14/19

Job Tracking No:

Due Date: 7/26/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG RBWST13045 Rev 3 IPP Rev A 18.02.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	7/26/19		0.00	0.33	Small Fab - 1		
							Small Fab - 2		MLC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	7/26/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		DAS 61 9-89
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	7/26/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		

DART
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Container No: S196981



Part: RBWST13045

Job No: 196556

Serial No/Batch: S196981

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/10/19

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				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	7/26/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

JUL 1 1 2019

GA 100

Part Op 100 - Small Fab - 1-Assemble as per DWG sheet 1 2-Orient -1 as shown 3-Use PERMATEx thread sealant as required.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location:
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
86 4M3K -	Hose 18" Oal W/MP & MPX	2 Ea (1 ea)	100-Small Fab - 1	5196312
44 50695K162 -	Zinc Plated Fitting 1/4 NPT x 1/16-20 JIC	2 Ea (1 ea)	100-Small Fab - 1	5055039
27 5232T243 -	Standard Tee 1/4 NPT	2 Ea (1 ea)	100-Small Fab - 1	5165836
27 5232T313 -	COUPLING 1/4 NPT TO 1/8 NPT	2 Ea (1 ea)	100-Small Fab - 1	5118702
27 5232T316 -	Hex Nipple 1/4 NPT TO 1/4 NPT	2 Ea (1 ea)	100-Small Fab - 1	5118695
48 5274T73 -	Polypropylene Vial	2 Ea (1 ea)	100-Small Fab - 1	5116860
27 6050T14 -	Zinc Plated Fitting 1/4 NPTF x 1/4 Plug	2 Ea (1 ea)	100-Small Fab - 1	5118704
48 6852K11 -	Squeeze Grip Valve	2 Ea (1 ea)	100-Small Fab - 1	5165838
22 8028 -	Schrader Valve	2 Ea (1 ea)	100-Small Fab - 1	5125476
48 8063K37 -	BRASS VALVE 1/4 NPT MALE x SCHRADER AIR VALVE	2 Ea (1 ea)	100-Small Fab - 1	5116880
31 AMF556 -	Bleeder Valve	2 Ea (1 ea)	100-Small Fab - 1	5175867
100 RBWST13045-7 -	Pressure Gauge	2 Ea (1 ea)	100-Small Fab - 1	5163569
10 RBWST13045-8 -	Boot	2 Ea (1 ea)	100-Small Fab - 1	1V 5163570

1V 5127084

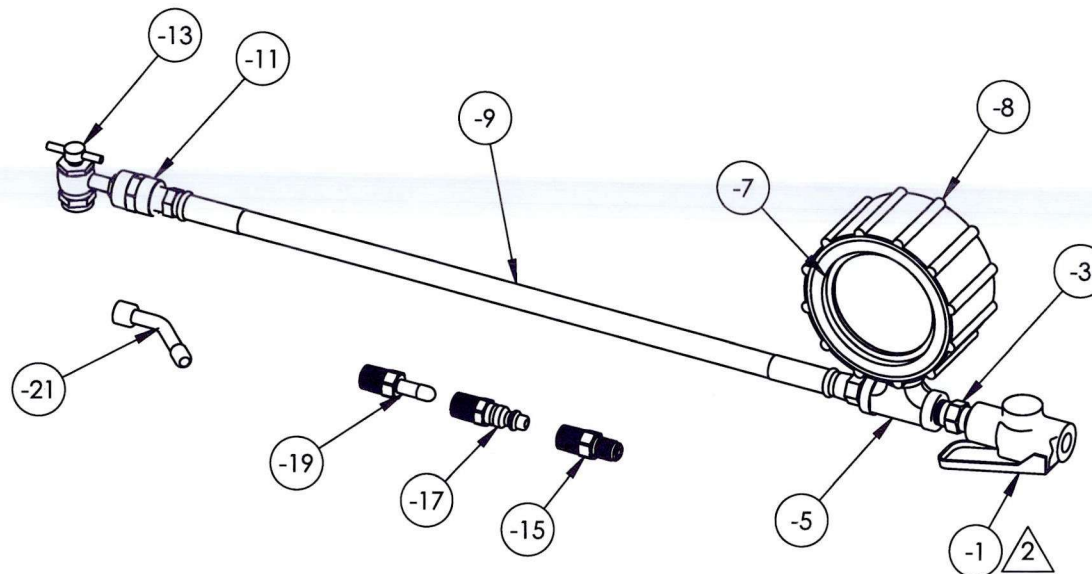
010836

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	4M3K	2	3	0
	50695K162	2	8	0
	5232T243	2	4	0
	5232T313	2	3	0
	5232T316	2	4	0
	5274T73	2	8	0
	6050T14	2	10	0
	6852K11	2	4	0
	8028	2	7	0
	8063K37	2	6	0
	AMF556	2	17	0
	RBWST13045-7 <i>2V</i>	2	0	0
	RBWST13045-8	2	0	0
Part Specifications				
Specifications could not be found.				

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-1 FLIPPED HANDLE VERTICAL, -9 UPDATED PART INFO, ADDED P/N -21 ADDED P/N.	1/4/2013	BIM	SE
B		CORRECTED ORIENTATION OF -1 TO FIT FOAM.	3/5/2014	JAG	GE
2	15-0299	-8 ADDED TO BOM, -19 MCMASTER-CARR #8063K38 NO LONGER AVAILABLE USE #8063K37.	9/14/2015	RJC	JAG
3	16-0100	UPDATED TO NEW STANDARD -7 CH'D B/O PART NUMBER WAS 2 1/2 PFG807CD IS 2-1/2 PFG807.	8/9/2016	DEW	SM



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WITHOUT NOTICE
WORK ORDER
NO. 196556

NOTE:
1. USED IN KIT RBW1205G00131-3G.
2. ORIENT -1 AS SHOW.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	-1	1	VALVE	ZINC ALLOY	(MCMASTER-CARR #6852K11)	1
		B/O	-3	1	HEX NIPPLE	ZINC-PLATED STEEL	1/4 NPT TO 1/4 NPT (MCMASTER-CARR #5232T316)	1
		B/O	-5	1	STANDARD TEE	ZINC-PLATED STEEL	1/4 NPT (MCMASTER-CARR #5232T243)	1
		B/O	-7	1	GAUGE		PARAMOUNT SUPPLY #2-1/2 PFG807	1
		B/O	-8	1	BOOT	RUBBER	PARAMOUNT SUPPLY #25	1
		B/O	-9	1	HOSE		PACIFIC RUBBER P/N 4M3K@ 18" OAL W/ MP& MPX (CRIMPED)	1
		B/O	-11	1	COUPLING	ZINC-PLATED STEEL	1/4 NPT TO 1/8 NPT (MCMASTER-CARR #5232T313)	1
		B/O	-13	1	BLEEDER	PLATED STEEL	PACIFIC RUBBER #AMF556	1
		B/O	-15	1	FITTING	ZINC-PLATED STEEL	1/4 NPT X 7/16-20 JIC (MCMASTER-CARR #50695K162)	1
		B/O	-17	1	FITTING	ZINC-PLATED STEEL	1/4 NPTF X 1/4 PLUG (MCMASTER-CARR #6050T14)	1
		B/O	-19	1	VALVE	BRASS	1/4 NPT MALE X SCHRADER AIR VALVE (MCMASTER-CARR #8063K37)	1
		B/O	-21	1	VALVE		P/N 22596 SCHRADER 8028	1
		B/O	-23	1	VIAL	POLYPROPYLENE	(MCMASTER-CARR #5274T73)	NS

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TITLE
TIRE INFLATOR GAUGE, NITROGEN

DWG NO. RBWST13045

REV 3

MATERIAL		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		XXX ± .005 FRACTIONS ± 1/8	
SPEC		XX ± .01 ANGLES ± 5°	
DRAWN BY: GILBERT		X ± .1 SURFACES = 125	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: MACKOVJAK		AFTER PLATING	
SCALE 1:4		3. INTERPRET DIM AND TOL PER	
DATE 12/19/2011		ASME Y14.5M-2009	
SHEET 1 OF 1		USED ON MODEL	
		AW139	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

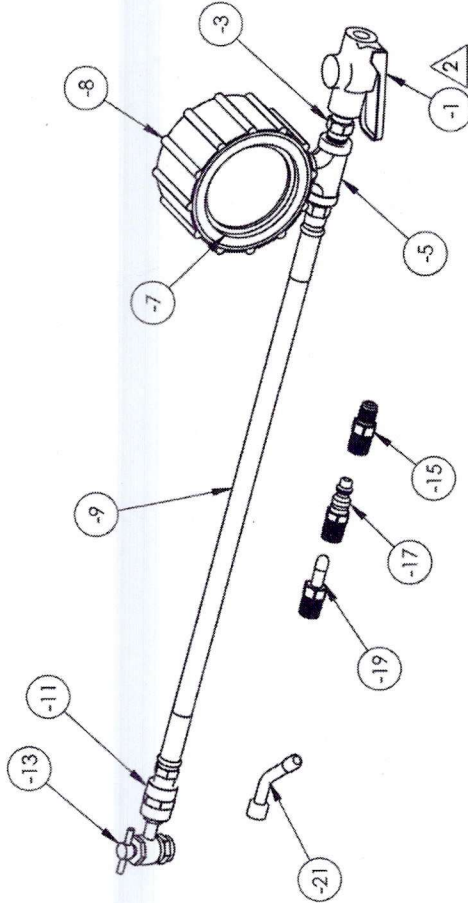
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-1 FLIPPED HANDLE VERTICAL. -9 UPDATED PART INFO, ADDED P/N -21 ADDED P/N.	1/4/2013	BIM	SE
B		-1 CORRECTED ORIENTATION OF -1 TO FIT FOAM.	3/5/2014	JAG	GE
2	15-0299	-8 ADDED TO BOM. -19 MCMASTER-CARR #8063K37.	9/14/2015	PJC	JAG
3	16-0100	UPDATED TO NEW STANDARD -7 CHD 8/O PART NUMBER WAS 2 1/2 PFG807.	8/9/2016	DEW	SM
E	14-543	ITEM # WAS RBWST13045 IS RBWST13045	1/31/2019	PK	PK

3 NOTE 1 REVISED.



PK

RBW1205G00132-3G.

NOTE:
1. USED IN KIT RBW1205G00131-3G.

2. ORIENT -1 AS SHOWN.

DART
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TIRE INFLATOR GAUGE, NITROGEN

REV 3E
RBWST13045

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
XXX ± .005 FRACTIONS 1/8
XX ± .01
X ± .015
1. BREAK ALL SHARP EDGES
2. DIMENSIONAL LIMITS APPLY
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009
USED ON MODEL
AW139
APPROVED: MACKONPK PK
SCALE 1:4 DATE 12/19/2011 SHEET 1 OF 1

ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	B/O	-1	1	VALVE	ZINC ALLOY	(MCMASTER-CARR #6852K11)	1
	B/O	-3	1	HEX NUT	ZINC-PLATED STEEL	1/4 NPT TO 1/4 NPT (MCMASTER-CARR #5232T314)	1
	B/O	-5	1	STANDARD TEE	ZINC-PLATED STEEL	1/4 NPT (MCMASTER-CARR #5232T243)	1
	B/O	-7	1	GAUGE	RUBBER	PARAMOUNT SUPPLY #2-1/2 PFG807	1
	B/O	-8	1	BOOT	RUBBER	PARAMOUNT SUPPLY #25	1
	B/O	-9	1	HOSE	ZINC-PLATED STEEL	PACIFIC RUBBER P/N M3K3 18" OAL W/ MP& MPX (CRIMPED)	1
	B/O	-11	1	COUPLING	PLATED STEEL	1/4 NPT TO 1/8 NPT (MCMASTER-CARR #5232T313)	1
	B/O	-13	1	BLEEDER	ZINC-PLATED STEEL	PACIFIC RUBBER #AMF556	1
	B/O	-15	1	FITTING	ZINC-PLATED STEEL	1/4 NPT X 7/16-20 JIC (MCMASTER-CARR #5049SK162)	1
	B/O	-17	1	FITTING	ZINC-PLATED STEEL	1/4 NPT X 1/4 PLUG (MCMASTER-CARR #6050T14)	1
	B/O	-19	1	VALVE	BRASS	1/4 NPT MALE X SCHRAEDER AIR VALVE (MCMASTER-CARR #8063K37)	1
	B/O	-21	1	VALVE	POLYPROPYLENE	P/N 22596 SCHRAEDER 8028	1
	B/O	-23	1	VIAL	POLYPROPYLENE	(MCMASTER-CARR #527473)	1